



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2857-1
Job Sheet 211146



Part No: D2857-1

Job Qty: 10 pcs

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/7/20

Job Tracking No:

Due Date: 7/20/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC IPP D

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs	7/18/20	7/18/20	0.00	0.35	Bandsaw - 1		ALA 20/07/18
110	HAAS 4 Axis - B4B	10 pcs	7/18/20	7/18/20	0.13	5.53	HAAS - 1 - B4B		ALA 20/07/18
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	10 pcs	7/18/20	7/18/20	0.00	0.00	QC 8 - 12		mk 20/07/20
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



Container No: S288961



Part: D2857 - 1
Job No: 211146
Serial No/Batch: S288961
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
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TEL : 1 513 632-5200
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Date: 07/20/20



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					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
140	Handfinish - 1-1 Chemical-B4B	10 pcs	7/18/20	0.00 0.22	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	Powdercoat - 1 White Gl(A)-B4B <i>M 254469</i>	10 pcs	7/20/20	0.00 0.15	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
170	QC 3	10 pcs	7/20/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	

2004/07/17

20 07 22

START 1:15

O.T: 300

FINISH 1:15

34
9-89

					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	DAS
					QC 3 - 61	82
					QC 3 - 81	9-89
					QC 3 - 82	JUL 23 2020
					QC 3 - 87	
180	Packaging 3-1 - Stock - B4B	10	7/20/20	0.00 0.00	Packaging 3 - 1 - B4B	
		pcs			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
190	QC 21 - SA	10	7/20/20	0.00 0.00	QC 21 - SA - 21	JUL 23 2020
						DAS
						77
						9-89

pcs

QC 21 - SA - 70

Broussard

QC 21 - SA - 9

QC 21 - SA - 77

DAS

77

JUL 23 2020

9-89

Part Op 100 - (Bandsaw) Cut blanks 4.425"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FA940 DWG REV: C 2-Deburr any rough edges

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X2.000	6061T6 Bar 1.250 X 2.000	3.7000 ft (.37 ea) 4.44"	100-Bandsaw - 1	5221912 X8 5216003 X2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X2.000	4	38	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	4.300inches ± 0.010	4.310 4.290	4.300	
2	Hinge Bracket	4.000inches ± 0.010	4.010 3.990	4.002	
3	Hinge Bracket	0.340inches ± 0.010	0.350 0.330	339	
4	Hinge Bracket	1.110inches ± 0.005	1.115 1.105	1.110	
5	Hinge Bracket	1.790inches ± 0.010	1.800 1.780	1.790	
6	Hinge Bracket	1.320inches ± 0.005	1.325 1.315	1.319	
7	Hinge Bracket	2.000inches ± 0.010	2.010 1.990	2.001	
8	Hinge Bracket	0.340inches ± 0.010	0.350 0.330	340	
9	Hinge Bracket	0.447inches ± 0.010	0.457 0.437	447	
10	Hinge Bracket	0.171inches + 0.005 - 0.000	0.176 0.171	173	
11	Hinge Bracket	0.147inches ± 0.010	0.157 0.137	143	
12	Hinge Bracket	0.376inches ± 0.010	0.386 0.366	373	
13	Hinge Bracket	0.126inches ± 0.010	0.136 0.116	1255	
14	Hinge Bracket	0.063inches ± 0.010	0.073 0.053	063	
15	Hinge Bracket	0.166inches + 0.005 - 0.000	0.171 0.166	166	
16	Hinge Bracket	0.911inches ± 0.010	0.921 0.901	912	
17	Hinge Bracket	0.600inches ± 0.010	0.610 0.590	601	
18	Hinge Bracket	0.125inches ± 0.010	0.135 0.115	129	
19	Hinge Bracket	0.150inches ± 0.010	0.160 0.140	148	